

Date: Wednesday, 2/15/2006 3:50:20 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number :	25861		
Estimate Number :	10533		
P.O. Number :	N/A	Part Number :	D2573
This Issue :	2/15/2006	Drawing Number :	D2573 REV E
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	N/A	Drawing Revision :	E
Previous Run :	25832	Material :	N/A
Written By :	See comment below	Due Date :	3/10/2006
Checked & Approved By :	06.02.16	Qty:	6
Comment :	Est: I As Per RevE 06-01-27 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
-----	----------	--------------------------



adj: 24070
24070
 Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2573

Ensure that grain is along 7.75" length

Batch No: *B24070 (4)**B 29941 (2)**J.G**06103107**6*

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. *B25861* Double check by: *SG*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

*J.G**06103107**6*

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

*SG**J.G**06103107**6*

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SG**J.G**06103111**6*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SD Date: 06/03/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:
User:

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 25861

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BG 06-03-13

6

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06-03-14

6

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MM 06-03-14

(6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

DL 06/03/14

(C)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST479

C 06/03/15

(6)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/15

(6)

Job Completion



06-03-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25861
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.746	1.745	1.747		
C	3.495	3.505		3.498	3.496	3.496	3.498		
D	1.745	1.755		1.746	1.746	1.745	1.747		
E	7.990	8.010		8.005	8.004	8.004	8.006		
F	0.490	0.510		0.497	0.500	0.499	0.498		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.498	0.501	0.502	0.502		
J	1.174	1.184		1.176	1.177	1.176	1.177		
K	0.558	0.578		0.564	0.564	0.567	0.566		
L	1.174	1.184		1.176	1.177	1.176	1.177		
M	1.365	1.375		1.367	1.368	1.368	1.368		
N	2.495	2.505		2.496	2.496	2.496	2.496		
O	4.119	4.129		4.121	4.121	4.121	4.121		
P	0.115	0.135		0.123	0.122	0.125	0.126		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.249	0.248	0.250	0.250		
S	0.115	0.135		0.126	0.126	0.126	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.236	0.236	0.234	0.236		
W	0.115	0.135		0.132	0.132	0.132	0.130		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.634	0.630	0.631		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.242	0.244	0.244	0.246		
AE	1.500	1.520		1.515	1.514	1.516	1.516		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.247	0.251	0.253	0.241		
AI	2.000	2.020		2.005	2.004	2.005	2.006		
AJ	0.023	0.043		0.030	0.030	0.030	0.031		
Accept/Reject									

Measured by:	EP/S.G
Date:	06/03/13

Audited by:	BG
Date:	06-03-13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

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D	1.745	1.755		1.745	1.745				
E	7.990	8.010		8.004	8.003				
F	0.490	0.510		0.502	0.501				
G	0.257	0.262	DT8683	0.257	0.257				
H	0.375	0.380	DT8684	0.375	0.375				
I	0.490	0.510		0.501	0.502				
J	1.174	1.184		1.177	1.177				
K	0.558	0.578		0.565	0.568				
L	1.174	1.184		1.177	0.177				
M	1.365	1.375		1.368	1.368				
N	2.495	2.505		2.496	2.496				
O	4.119	4.129		4.121	4.122				
P	0.115	0.135		0.121	0.125				
Q	0.115	0.135		0.130	0.130				
R	0.240	0.260		0.246	0.245				
S	0.115	0.135		0.125	0.128				
T	0.178	0.198		0.188	0.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		0.235	0.235				
W	0.115	0.135		0.130	0.129				
X	0.308	0.313		0.310	0.310				
Y	0.760	0.765		0.760	0.760				
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AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.632	0.631				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.245	0.246				
AE	1.500	1.520		1.512	1.514				
AF	0.115	0.135		0.130	0.130				
AG	0.240	0.280		0.260	0.266				
AH	0.240	0.260		0.246	0.247				
AI	2.000	2.020		2.001	2.003				
AJ	0.023	0.043		0.030	0.030				
Accept/Reject									

Measured by:	EP / S.G
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05.12.06

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